

Date: Thursday, 5/3/2007 11:32:00 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	GUIDE	
Job Number	32172				
Estimate Number	12705				
P.O. Number	N/A		Part Number	D35723	
This Issue	5/3/2007	S.O. No.	N/A	Drawing Number	D3572 REV.B
Prsht Rev.	NC		Project Number	N/A	
First Issue	N/A		Drawing Revision	B	
Previous Run	31912		Material	N/A	
Written By			Due Date	5/13/2007	
Checked & Approved By			Qty:	120	
Comment	Est Rev:A New Issue 07-02-07 JLM est rev B rev.B dwg EC		Um:	Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6B0750X03000	6061-T6 Bar .75" x 3.0"	
		Comment: Qty.: 0.0893 f(s)/Unit Total : 10.7100 f(s) 6061-T6 Bar .75" x 3.0" Batch: M1041326	
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blank 100" long	
3.0	HAAS	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1	
		1- Mill as per Folio FA685 Rev: A & Dwg D3572 Rev: B	
	2-Deburr per dwg D3572		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: LD Date: 07/05/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/3/2007 11:32:00 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 32172

Part Number: D35723

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EJ 07/05/22 (120)

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

150705/23

Job Completion



U 07.05.23

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32172
Description: Guide	Part Number:	D3572-3
Inspection Dwg: D3572 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

0.03

Measured by:	<i>Arn</i>	Audited by:	<i>J.L.</i>	Prototype Approval:	N/A
Date:	07/05/18	Date:	07/05/18	Date:	N/A

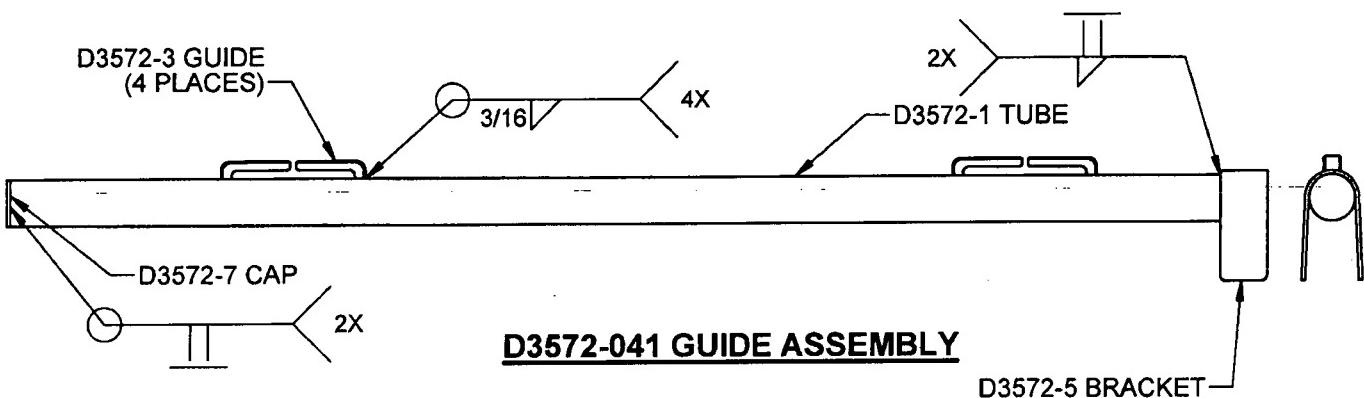
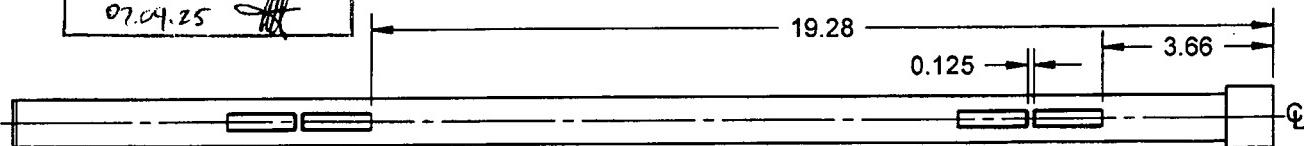
Rev	Date	Change	Revised by	Approved
A	07.05.01	New Issue	KJ/JLM	JL

DART

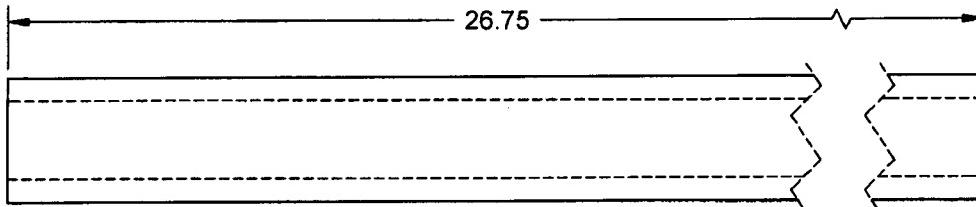
DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3572
DATE 07.04.20	TITLE GUIDE ASSEMBLY	REV. B SCALE 1:4
REV A	DATE 07.03.29	DESCRIPTION NEW ISSUE
REV B	DATE 07.04.20	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET

RELEASED

07.04.25

**D3572-041 NOTES:**

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3572-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) WELD PER DART QSI 004

**D3572-1 TUBE****D3572-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
(REF DART SPEC M6061T6T1.000W.188)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

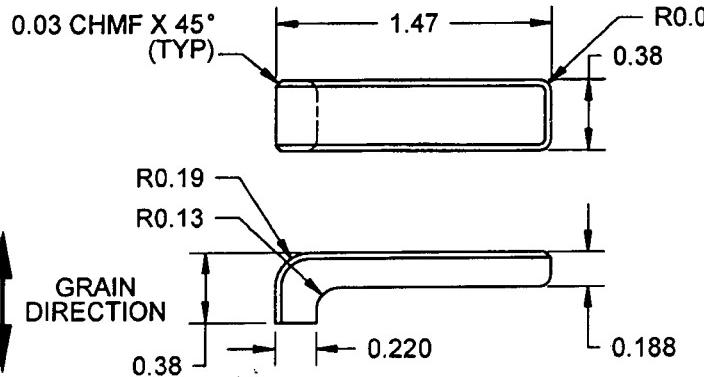
0.188 (REF)
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *30172*

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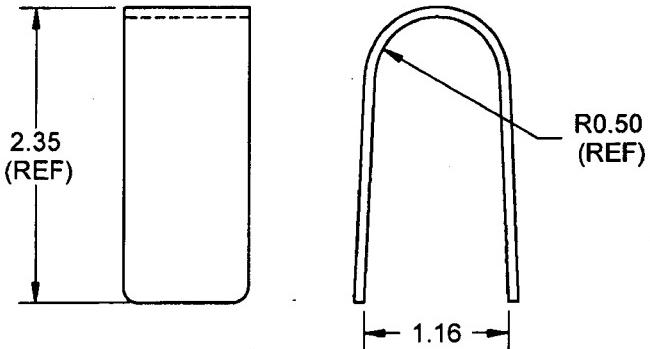
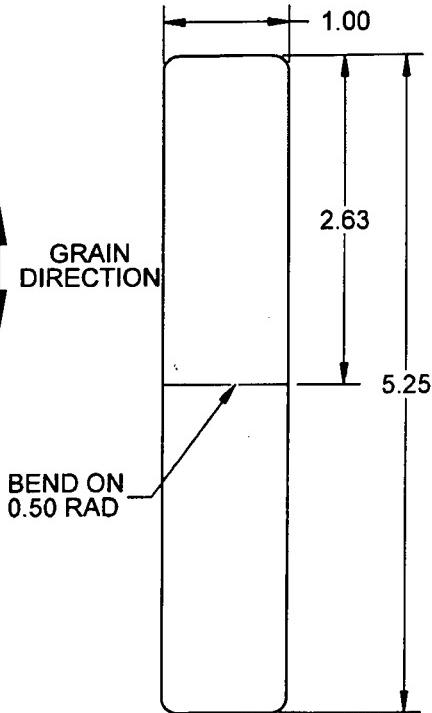
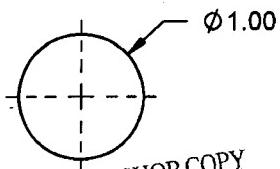
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DART

DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>CH</i>	DRAWING NO. D3572	REV. B SHEET 2 OF 2
DATE 07.04.20	TITLE GUIDE ASSEMBLY	SCALE 2:3	

**D3572-3 GUIDE****RELEASED**

07.04.25

**D3572-5 BRACKET**
(MAKE FROM D3572-5F)**D3572-5F FLAT PATTERN**

Ø 1.00

SHOP COPY
RETURN TO
ENGINEERING

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *3572*

D3572-3/-5/-7 NOTES:

- 1) D3572-3 MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR PER QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6B)
- 2) D3572-5/-7 MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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